

Work Order ID 83047

April-12-12 1:02:39 PM

83047

Page 1

Item ID: D206-781-151KGY

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Vertical Tunnel-Grey

Stop

NS2

Start Date: 12/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 26/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/12 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

100

100

DC

Document Control

Memo

0.00

Photocopy bluefile & type labels per PPP D206-781-151KGY (CHG 001)

110

110

Packaging

Packaging

Pick Kit

0.00

Memo

0.00

120

120

QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00

W 12/06/12

for MLJ 12-6-11

12/06/11 0

W 12/06/12

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B				Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Work Order ID 83047

April-12-12 1:02:39 PM

83047

Page 2

Item ID: D206-781-151KGY

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Vertical Tunnel-Grey

Stop

NS2

Start Date: 12/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 26/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Packaging

Packaging

Memo

0.00

12/12/12

Identify and pack for shipping as per PPP D206-781-151KGY

Location: _____
PPP rev B

140

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

12/16/12

12/06/12

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Picklist Print

April-12-12 1:02:43 PM

Page 1

Work Order ID: 83047

83047

Parent Item: D206-781-151KGY

D206-781-151KGY

Parent Item Name: Vertical Tunnel-Grey

Start Date: 12/04/2012

Required Date: 26/04/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS4632-130		Purchased	No			110	Each	985.0000	8	8			

AI S4632-130

insert

Location Loc Qty Loc Code

ST282 985

118908 985

110 Each 168.0000

**

118908 S u

4

ALS4-632-80

AI S4-632-80

Insert

Location Loc Qty Loc Code

ST282 168

112495 168

110 f 213.3140

**

112495 S u

4

D3800-1-100

D3800-1-100

Hook and Loop Strip (1" Soft)

Location Loc Qty Loc Code

ST063 213.314

68910 9.801

72233 9.841

75104 26.271

80073 167.401

**

112495 S u

4

(D3800-1-100-800) cut (2) at 80.00" per kit

2012-04-14

800 73 664

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-12-12 1:02:43 PM

Page 2

Work Order ID: 83047

Parent Item: D206-781-151KGY

Parent Item Name: Vertical Tunnel-Grey

83047
D206-781-151KGY

Start Date: 12/04/2012

Start Qty: 1.00

Required Date: 26/04/2012

Required Qty: 1.00

D3800-3-100

Manufactured No

110

f

219.3140

13.3

13.3

**

85308

D3800-3-100

Hook and Loop Strip (1" Hard)

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST063	219.314	
68915	18.301	
72771	2.341	
73007	5.001	
75105	13.67	
80077	180.001	

(D3800-3-100-800) cut (2) at 80.00" per kit

D3822-1KGY

Manufactured No

110

Each

1.0000

**

0

1

D3822-1KGY

Vertical Tunnel, LH-Grey

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST152	1	
73912	1	

D3822-2KGY

Manufactured No

110

Each

1.0000

**

0

1

D3822-2KGY

Vertical Tunnel, RH-Grey

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST152	1	
73910	1	

D3822-3KGY

Manufactured No

110

Each

1.0000

**

0

1

D3822-3KGY

Vertical Tunnel, Aft Center-Grey

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST156	1	
73914	1	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-12-12 1:02:43 PM

Page 3

Work Order ID: 83047

Parent Item: D206-781-151KGY

Parent Item Name: Vertical Tunnel-Grey

83047
D206-781-151KGY

Start Date: 12/04/2012

Start Qty: 1.00

Required Date: 26/04/2012

Required Qty: 1.00

D3822-5KGY

Manufactured No 110 Each 1.0000

0 1

**

D3822-5KGY

Vertical Tunnel, Top-Grey

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST150	1	
73911	1	

D3822-7KGY

Manufactured No 110 Each 1.0000

0 1

**

D3822-7KGY

Vertical Tunnel, Lower-Grey

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST150	1	
73913	1	

NAS388-6-12P

Purchased No 110 Each 114.0000

00 14

**

NAS388-6-12P

Screw

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST278	114	
116523	14	
120447	100	

NAS388-6-8P

Purchased No 110 Each 129.0000

0 4

**

NAS388-6-8P

Screw

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST278	129	
116416	29	
119673	50	
119716	50	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Picklist Print

April-12-12 1:02:43 PM

Page 4

Work Order ID: 83047

83047
D206-781-151KGY

Parent Item: D206-781-151KGY

Parent Item Name: Vertical Tunnel-Grey

Start Date: 12/04/2012

Required Date: 26/04/2012

Start Qty: 1.00

Required Qty: 1.00

NAS391B6P

NAS391R6P

Washer

Purchased

No

110

Each

160.0000

18

18

-

**

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST278	160	
116416	2	
118840	58	
118891	100	

118890-S

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B				Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

5.2 D206-781-141/-143/-151/-161/-171/-173/-191/-193 KITS

Qty -141	Qty -143	Qty -151	Qty -161	Qty -171	Qty -173	Qty -191	Qty -193	Part Number	Description
X								D206-781-141	CREW CABIN OVERHEAD W/O ROTOR BRAKE KIT
	X							D206-781-143	CREW CABIN OVERHEAD W/ ROTOR BRAKE KIT
		X						D206-781-151	VERTICAL TUNNEL KIT
			X					D206-781-161	REAR OVERHEAD KIT
				X				D206-781-171	HAT BIN KIT
					X			D206-781-173	HAT BIN KIT, LITTER KIT COMPATIBLE
						X		D206-781-191	CREW CABIN OVERHEAD W/ ROTOR BRAKE KIT
							X	D206-781-193	ROTOR BRAKE PANEL KIT
1								D3821-1	PANEL - W/O ROTOR BRAKE
	1							D3821-3	PANEL - W/ ROTOR BRAKE
4	4							NAS388-6-8P	SCREW
4	4							NAS391B6P	WASHER
	1							D3822-1	VERTICAL TUNNEL, LH
	1							D3822-2	VERTICAL TUNNEL, RH
	1							D3822-3	VERTICAL TUNNEL, AFT CENTER
	1							D3822-5	VERTICAL TUNNEL, TOP
	1							D3822-7	VERTICAL TUNNEL, LOWER
	2							D3800-1-100-800	LOOP STRIP
	2							D3800-3-100-800	HOOK STRIP
	4							NAS388-6-8P	SCREW
	14							NAS388-6-12P	SCREW
	18							NAS391B6P	WASHER
	4							ALS4-632-80	INSERT
	8							ALS4-632-130	INSERT
		1						D3823-1	REAR OVERHEAD, LH
		1						D3823-2	REAR OVERHEAD, RH
		1						D3823-3	REAR OVERHEAD, CENTER
		10						AN525-10R24	SCREW
		10						NAS43DD3-68	SPACER
		1						D3824-1	HAT BIN
			1					D3824-3	HAT BIN
		6	6					D3851-1	DOUBLER
		4	4					AN525-10R10	SCREW
				1				D4077-1	OVERHEAD PANEL, LH
				1				D4077-2	OVERHEAD PANEL, RH
					1			D4118-1	ROTOR BRAKE PANEL
					1			D4119-1	PANEL
					6			NAS388-6-8P	SCREW
						4		NAS388-6-12P	SCREW
						6	4	NAS391B6P	WASHER
							4	MS21059L06	NUTPLATE
							8	MS20426AD3-3	RIVET